

# Picasso Production Schedule

- 

## Picasso Production Schedule - Classic

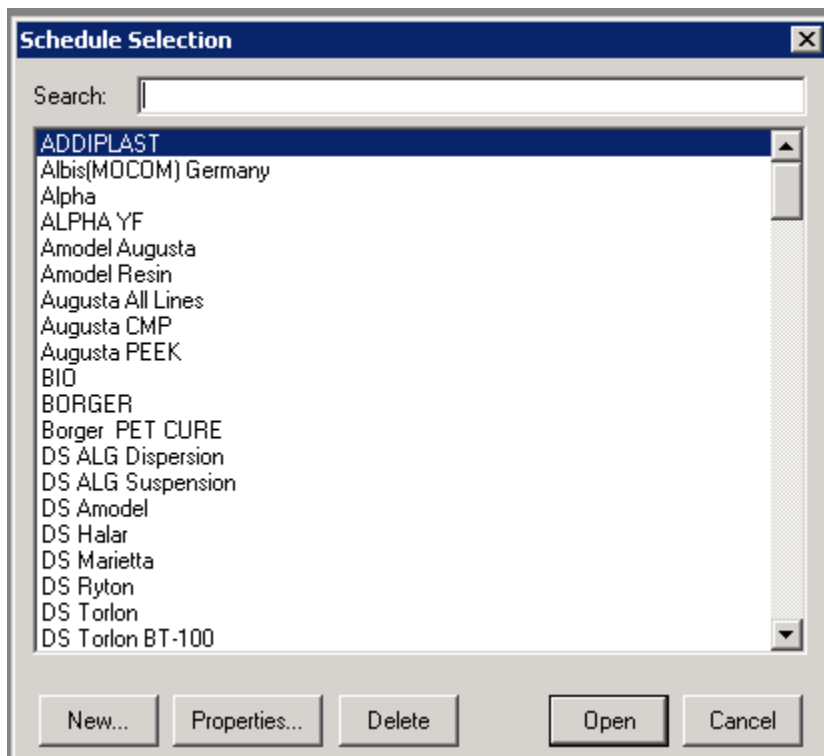
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## Dynamic Scheduling

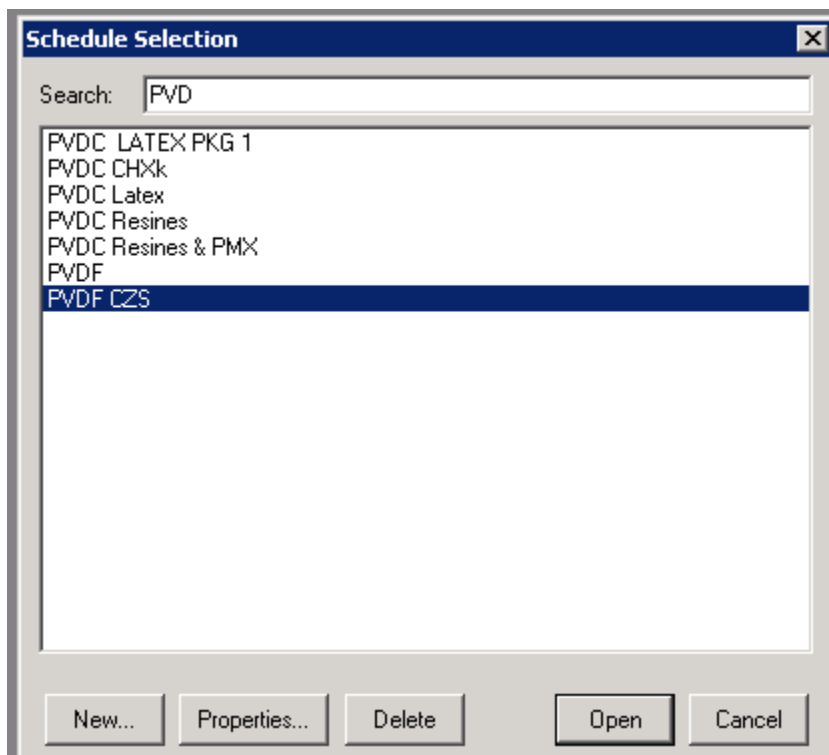
## Picasso Production Schedule - Classic

### Open a schedule

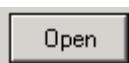
In Picasso, hit this icon:  . It opens a list of Schedules:



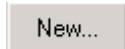
Use the search to find the one you need.



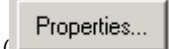
Once you find the one you were looking for, hit:



You may also create a schedule (hit:

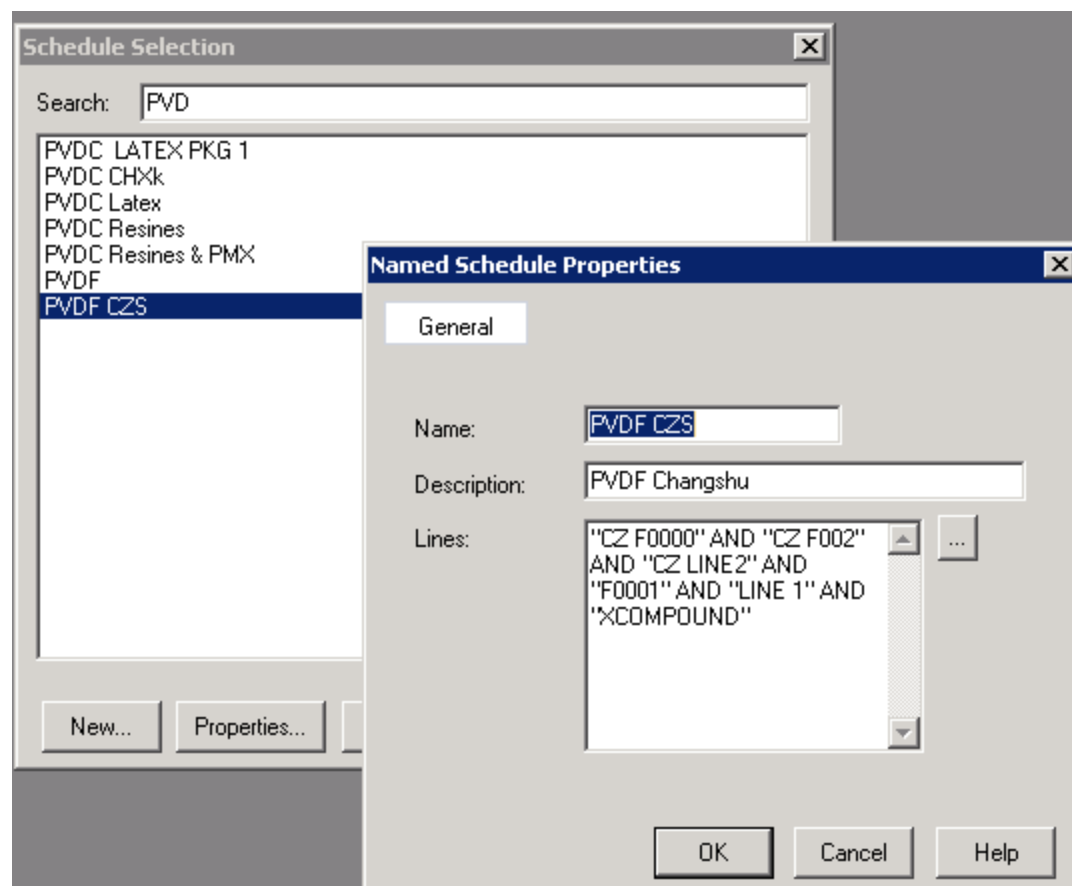


) and/or understand how a grid works by looking at its properties (

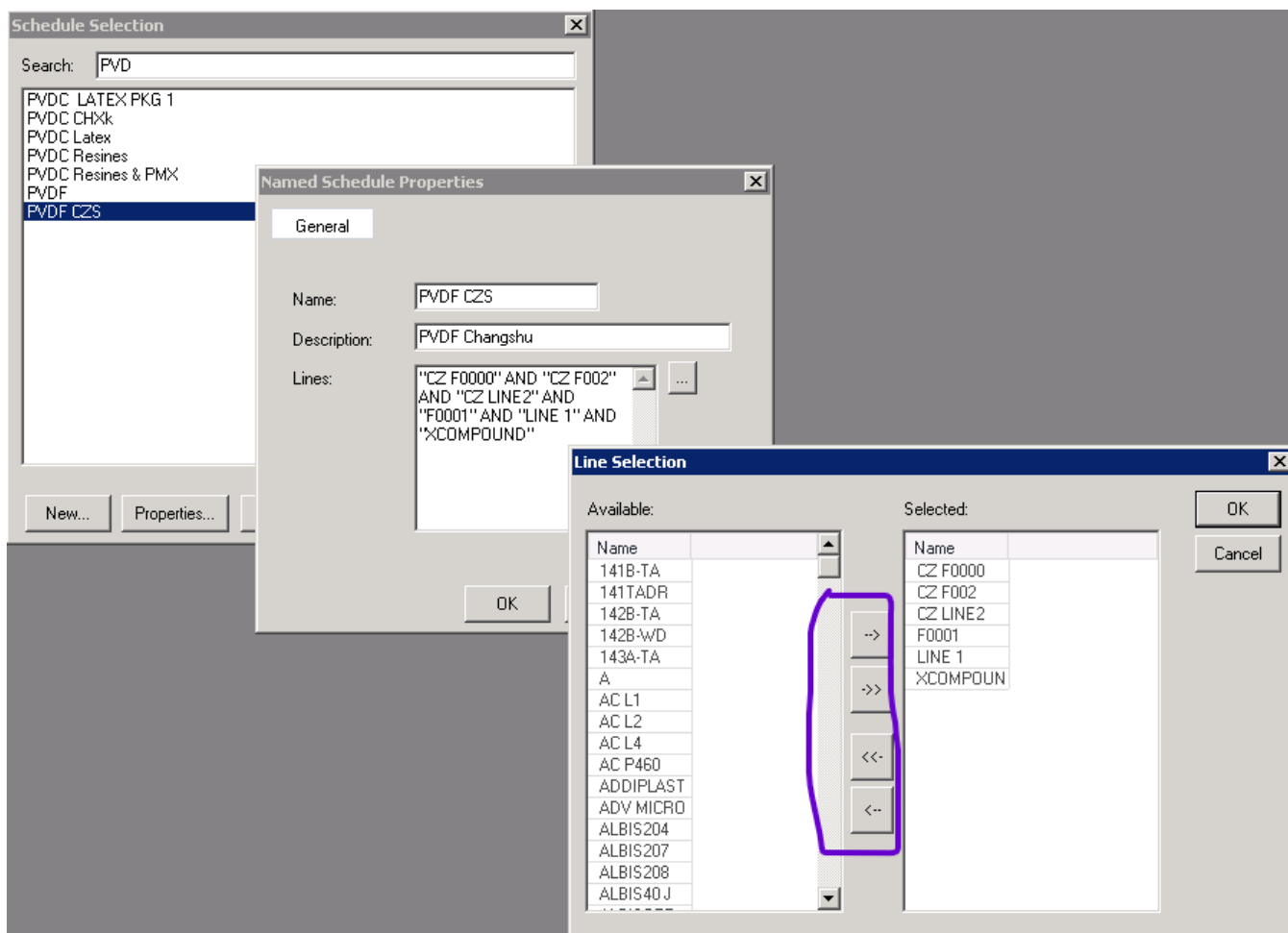


## Schedule properties

The schedule properties, beside its name and description, is mostly its a list of lines.



Use the  icon to open the inventory of lines; and use the arrow keys to update the list of lines.



All lines show next to each other, in a sequence that is determined by the equipment "Unit Position"

| [no color scheme]  |                      |                   |                     |                      |                       |         |        |            |            |        |               |             |           |              |
|--------------------|----------------------|-------------------|---------------------|----------------------|-----------------------|---------|--------|------------|------------|--------|---------------|-------------|-----------|--------------|
| Drag and drop runs |                      |                   |                     |                      |                       |         |        |            |            |        |               |             |           |              |
| LINE 1<br>CZS<br>R | CZ LINE2<br>CZS<br>R | F0001<br>CZS<br>F | CZ F002<br>CZS<br>F | CZ F0000<br>CZS<br>F | XCOMPOUND<br>CZS<br>F |         |        |            |            |        |               |             |           |              |
| Nov 22             |                      |                   |                     |                      |                       |         |        |            |            |        |               |             |           |              |
| Nov 23             |                      |                   |                     |                      |                       |         |        |            |            |        |               |             |           |              |
| 12:00              |                      |                   |                     |                      |                       |         |        |            |            |        |               |             |           |              |
| Nov 24             |                      |                   |                     |                      |                       |         |        |            |            |        |               |             |           |              |
| 12:00              |                      |                   |                     |                      |                       |         |        |            |            |        |               |             |           |              |
| Nov 25             |                      |                   |                     |                      |                       |         |        |            |            |        |               |             |           |              |
| 12:00              |                      |                   |                     |                      |                       |         |        |            |            |        |               |             |           |              |
| Nov 26             |                      |                   |                     |                      |                       |         |        |            |            |        |               |             |           |              |
| 12:00              |                      |                   |                     |                      |                       |         |        |            |            |        |               |             |           |              |
| Nov 27             |                      |                   |                     |                      |                       |         |        |            |            |        |               |             |           |              |
| 12:00              |                      |                   |                     |                      |                       |         |        |            |            |        |               |             |           |              |
| Nov 28             |                      |                   |                     |                      |                       |         |        |            |            |        |               |             |           |              |
| 12:00              |                      |                   |                     |                      |                       |         |        |            |            |        |               |             |           |              |
| Nov 29             |                      |                   |                     |                      |                       |         |        |            |            |        |               |             |           |              |
| 12:00              |                      |                   |                     |                      |                       |         |        |            |            |        |               |             |           |              |
| Nov 30             |                      |                   |                     |                      |                       |         |        |            |            |        |               |             |           |              |
| 12:00              |                      |                   |                     |                      |                       |         |        |            |            |        |               |             |           |              |
| Pid                | Product Description  | Pkg Unit          | Qty (net)           | Rate                 | Op% Yield             | Formula | Run Id | Start Date | Start Time | Dur    | Product Name  | Qty (gross) | Run Ref # | Status       |
| P 513              | PVDF 5130/1001 CZ    | BL LINE 1         | 208.00 MT           | 0.58 MT / Hour       | 80.00 00.00           | 82      | 44101  | 11/21/2022 | 12:00 AM   | 384.18 | P 5130/1001 I | 208.00 MT   | 00018783  | 000060397201 |

# Schedule properties - Edit Display

EDIT SCHEDULE Properties

Each User can display fields in the sequence you want from top to bottom

For example display Product description on top line then Qty on next line , etc

System will save for each User

## Navigation

### Navigation buttons

|                                                                                   |                       |
|-----------------------------------------------------------------------------------|-----------------------|
|                                                                                   |                       |
|  | jumps to today        |
|  | zoom in - horizontal  |
|  | zoom out - horizontal |
|  | zoom in - vertical    |
|  | zoom out - vertical   |

### Color schemes

TBC

### Linking runs together

| Key                                                                                 | Function                                                                                                                                       |
|-------------------------------------------------------------------------------------|------------------------------------------------------------------------------------------------------------------------------------------------|
|  | Select two runs, then hit this key. Runs are now linked in a predecessor / successor relationship. See <a href="#">Predecessor/Successor</a> . |
|  | To cancel the relationship.                                                                                                                    |

### Candidate runs

Picasso generated runs. Resulting from imbalance between demand and supply

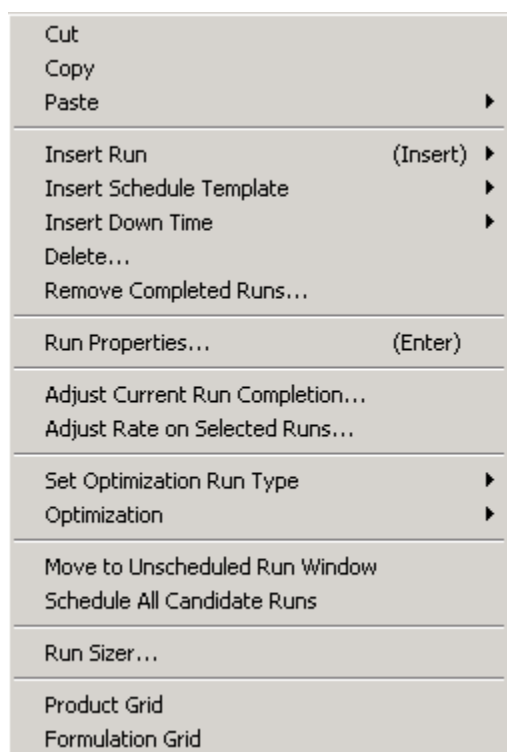
### Run details

|       |                     |             |           |                |       |       |         |        |            |            |        |               |             |           |        |              |                                  |  |  |
|-------|---------------------|-------------|-----------|----------------|-------|-------|---------|--------|------------|------------|--------|---------------|-------------|-----------|--------|--------------|----------------------------------|--|--|
| 12:00 |                     |             |           |                |       |       |         |        |            | 00:00 MT   |        |               |             |           |        |              |                                  |  |  |
| Pd    | Product Description | Pkg Unit    | Qty (net) | Rate           | Op%   | Yield | Formula | Run Id | Start Date | Start Time | Dur.   | Product Name  | Qty (gross) | Run Ref # | Status | Cust Order   | Notes                            |  |  |
| P 513 | PVDF 5130/1001 CZ   | BL CZ LINE2 | 657.00 MT | 1.20 MT / Hour | 80.00 | 00.00 | 85      | 43487  | 11/01/2022 | 12:00 AM   | 684.37 | P 5130/1001 I | 657.00 MT   | 00018299  |        | 000060395811 | Test Gaelig to see if SAP is con |  |  |

### Inserting a run on the schedule

#### From scratch

Position your cursor on the production line / existing run on that line. Right click:



and select " ".

You may insert a run after or before an existing run:



It opens a window as below:

Run Properties

General

Formula

Predecessors

Successors

Notes

Orders

Line:

XCOMPOUND

Sku Code:

0204346

PVDF 6008/0001

Product:

P 6008/0001 CZ

PVDF 6008/0001 CZ

Package:

BJ

BAGS, 25 KG

Formula:

80(0001-CZS-BJ -PVDF 6008/0001 \*CZ

Start :

11 / 27 / 2022

at: 07 : 15 : 00

☐ Run Should Start On or After this date and time:

/

/

at:

:

:

Lot Size:

1.0000

MT

Quantity:

0.00

MT

0.00 MT

Gross Production at

100

% Yield and

80.00

Op %

Rate:

0.4000

MT/Hour

<<

0.4000 (std rate)

Duration:

0

days

0

hr

0

min

Ends:

11 / 27 / 2022

at: 07 : 15 : 00

Run Reference #:

☐ Output Reported

Status:

☐ Completed

Customer Order:

☒ Exportable

Lot Number:

Type:

Free

Link Info:

Calc Size

OK

Cancel

## Header Tab

In that window, populate either the SKU, or the Picaso material & package code. Picaso will pull in complementary data.

The [default formula](#) auto-populates. You may pick another valid formula if necessary.

Valid means: within validity date & formula assigned to the relevant production line via [production standard effectivity](#).

For this product/package/line, there is only one production standard effectivity:

Would there be more than one, the one with the default check mark would be selected automatically by default (duh!).

## Start Date/Time

Line:

XCOMPOUND

Sku Code:

0204346

PVDF 6008/0001

Product:

P 6008/0001 CZ

PVDF 6008/0001 CZ

Package:

BJ

BAGS, 25 KG

Formula:

80(0001-CZS-BJ -PVDF 6008/0001 \*CZ

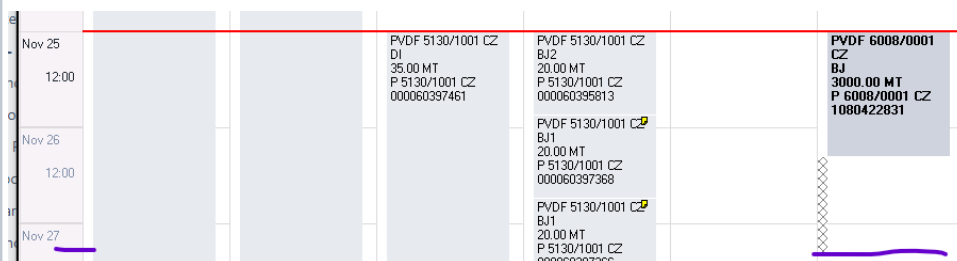
| Production Standard Effectivity (Unit = XCOMPOUND, Material = P 6008/0001 CZ, Package = BJ ) |           |                |         |         |                |                 |      |
|----------------------------------------------------------------------------------------------|-----------|----------------|---------|---------|----------------|-----------------|------|
| Production Standard                                                                          | Unit      | Material       | Package | Formula | Effective Date | Expiration Date | Rate |
| XCOMPOUND / P 6008/0001 CZ / BJ                                                              | XCOMPOUND | P 6008/0001 CZ | BJ      | 80      | 8/12/2022      | 12/31/2099      | 0.4  |

As per previous run (+transition), the new run can start Nov 27 at 7:15 am the earliest.

Start : 11 / 27 / 2022 at 07 : 15 : 00

☐ Run Should Start On or After this date and time:

/ / at : : :



You may also anchor the new run to a given date /time (here, we indicate that we want the new run to start no earlier than Nov 30 at 8:15 am)

Start : 11 / 27 / 2022 at 07 : 15 : 00

☒ Run Should Start On or After this date and time:

11 / 30 / 2022 at 08 : 15 : 00

## Quantity/Duration

Enter a quantity:

It results in the duration of the run being recalculated as per rate (here, 0.4 MT/h), [Up Time](#) from the line (or Op, here = 80%), and [yield](#) (here = 100 %)

Lot Size: 1.0000 MT

☐ Quantity: 0 MT

0.00 MT Gross Production at 100 % Yield and 80.00 Op %

☐ Rate: 0.4000 MT/Hour << 0.4000 (std rate)

☒ Duration: 0 days 0 hr 0 min Ends: 11 / 30 / 2022 at 08 : 15 : 00

Duration = 10 MT / (0.4 MT/h) = 25 h.

However, a 80 % **Up Time** affects negatively the **duration**: 25 h / 0.8 = 31.25 h. Or 1 day, 7h, and 15 min.

The yield is 100 %, therefore it does not affect the run duration.

Lot Size: 1.0000 MT

☐ Quantity: 10 MT

10.00 MT Gross Production at 100 % Yield and 80.00 Op %

☐ Rate: 0.4000 MT/Hour << 0.4000 (std rate)

☒ Duration: 1 days 7 hr 15 min Ends: 12 / 01 / 2022 at 15 : 30 : 00

If the **yield** was set to 80% (you can modify it in the run, and it will only affect that run), it would result in both:

- **longer run duration**: 31.25 h / 0.8 = 39.06 h. Or 1day, 15h, and 4 min
- **increased Gross Production**: 10 MT / 0.8 = 12.5 MT
  - **net production unchanged** (i.e. what is seen on the grid and affects projected inventory) remains at 10 MT
- **increased component consumption** (see [Effect of yield on components quantity](#)).

Lot Size: 1.0000 MT

☐ Quantity: 10.00 MT

12.50 MT Gross Production at 80 % Yield and 80.00 Op %

☐ Rate: 0.4000 MT/Hour << 0.4000 (std rate)

☒ Duration: 1 days 15 hr 4 min Ends: 12 / 01 / 2022 at 23 : 19 : 00

The standard rate is pulled from the production standard efficiency (through the formula picked for that run).

| Production Standard             | Unit      | Material       | Package | Formula | Effective Date | Expiration Date | Rate | Default |
|---------------------------------|-----------|----------------|---------|---------|----------------|-----------------|------|---------|
| XCOMPOUND / P 6008/0001 CZ / BJ | XCOMPOUND | P 6008/0001 CZ | BJ      | 80      | 8/12/2022      | 12/31/2099      | 0.4  |         |

The rate can be modified in the run itself. It will only affect that run and its duration.

Lot Size:  MT

☐ Quantity:

10.00 MT Gross Production at  % Yield and 80.00 Op %

☐ Rate:  MT/Hour << 0.4000 (std rate)

☒ Duration:  days  hr  min Ends:  /  /  at:  :  :

Hit << to revert to the standard rate.

blocked URL

Note that you may enter quantity with [alternative units of measures or multiples of lot size](#):

Lot Size:  MT

☐ Quantity:

0.00 MT

☐ Rate:  MT/Hour

## Run references

Run Reference #:

Status:

Customer Order:

Lot Number:

Link Info:

☐ Output Reported

☐ Completed

☒ Exportable

Type:

| Field               | Description                                                                                                                                                                                                                      |
|---------------------|----------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|
| The Run Reference # | is a Picaso internal reference number that is automatically generated once the run is saved.                                                                                                                                     |
| Customer Order      | Once a run has been uploaded to SAP and a Planned order/Process order as been created in SAP, the SAP number populates the Customer Order field.<br><br>Find more about the Picaso Schedule upload to SAP <a href="#">here</a> . |
| Lot Number          | If an output lot number is assigned to a Process order in SAP, it will also show here.                                                                                                                                           |
| Exportable          | The Exportable checkbox is inherited from the <a href="#">equipment</a> . It can also be checked on or off by hand. If active, that run is selected for upload to SAP.                                                           |
| Output Reported     | When activated, this flag indicates that production is complete, resulting in the run not affecting the plot nor the grid nor any query any longer.                                                                              |
| Completed           | will not interface with SAP.<br><br>Even when activated, the run still shows on the grid, the plot and PicReports.                                                                                                               |
| Type                | Fixed: Dynamic Scheduling ( DS ) will not delete run when updating schedule; Free -DS will delete run when updating schedule                                                                                                     |

## Formula

The formula tab of a run shows the components of said run. Here, only one component.

GeneralFormulaPredecessorsSuccessorsNotesOrders

| Raw Material   | Prod Nome Name    | Responsible | Responsible \$    |
|----------------|-------------------|-------------|-------------------|
| P 6008/1001 CZ | PVDF 6008/1001 CZ | 0057158     | PVDF 6008/1001 CZ |

AddModifyDelete

Hit the 

Add

 button to insert more components.

Highlight the component and hit the 

Modify

 button to display/modify the component's

- consumption rate (100%)
- resulting quantity (-10 MT)
- usage (consumption, since this is a component)
- type (continuous)
- lag (0 days, i.e. no lag)

Run Properties

GeneralFormulaPredecessorsSuccessorsNotesOrders

| Raw Material   | Prod Nome Name    | Responsible | Responsible \$    |
|----------------|-------------------|-------------|-------------------|
| P 6008/1001 CZ | PVDF 6008/1001 CZ | 0057158     | PVDF 6008/1001 CZ |

ModifyDelete

Edit Formulation Component: (Product=P 6008/0001 CZ, Formula=80)

Component Information

Component:

P 6008/1001 CZ

Package:

BU

Amount used:

100.000000

%

Quantity:

-10.000000

MT

Usage

☒ Consumed

☐ Pkg Consumed

☐ Produced

Type

☐ Beginning

☒ Continuous

☐ End

Offset

☐ Lead (-)

☒ Lag (+)

0

Days

0

Hours

OKCancel

OKCancel

These values are auto-populated from the standard formula details:

Formula Details (Formula Number = 80, Material = P 6008/0001 CZ)

RefreshEditAddCopyDeleteShow/Hide FilterClear FilterExcel ImportExcel ExportReset

| Formula | Material       | Element        | Package | In/Out | Units | Amount | I/O Type   |
|---------|----------------|----------------|---------|--------|-------|--------|------------|
| 80      | P 6008/0001 CZ | P 6008/1001 CZ | BU      | Input  | % Wgt | 100    | Continuous |

Editing Formula Details (Formula Number = 80, Material = P 6008/0001 CZ)

\*Formula Number80

\*MaterialP 6008/0001 CZ

\*ElementP 6008/1001 CZ

\*PackageBU

\*In/OutInput

\*Units% Wgt

\*Amount Used100

\*I/O TypeContinuous

IO Lag (Hours)0

SaveCancel

Effect of yield on components quantity

Using the example above: 80% yield results in an increased component consumption:

- increased : -10 MT / 0.8 = -12.5 MT

Component Information

Component:P 6008/1001 CZ

Package:BU

Amount used:100.000000%

Quantity:-12.500000MT

Contrary to output gross production, the effect of a yield is visible on the component's grid.

Predecessor / Successor

By default, a predecessor / successor relationship links together two consecutive runs on the same production line.

Insert Run (Insert)Before...After...action

Insert Schedule Template

When inserting a run, the **Insert Schedule Template** decides what is going on with the relationship.

XCOMPOUND  
CZS  
F

PVDF 6008/0001 CZ  
BJ  
10.00 MT  
P 6008/0001 CZ

Predecessor

PVDF 6008/0001  
CZ  
BJ  
10.00 MT

Reference

Run Properties

| General      |                |     |           |                   |
|--------------|----------------|-----|-----------|-------------------|
| Formula      |                |     |           |                   |
| Predecessors |                |     |           |                   |
| Successors   |                |     |           |                   |
| Notes        |                |     |           |                   |
| Orders       |                |     |           |                   |
| Id           | Process        | Pkg | Line      | Prd Desc          |
| 44061        | P 6008/0001 CZ | BJ  | XCOMPOUND | PVDF 6008/0001 CZ |

Calc Size

OK

Cancel



ox lets y

[illegible]

Link Properties

Predecessor: ID: 18781812 P 6008/0001 CZ

Successor: ID: 44013 P 6010/1001 CZ

OK

Cancel

Swap

Link Type: **Finish-to-Start (FS)** Regular

Cleanout Time: 0 days 0 hrs 0 mins

Down Time: 0 days 0 hrs 0 mins

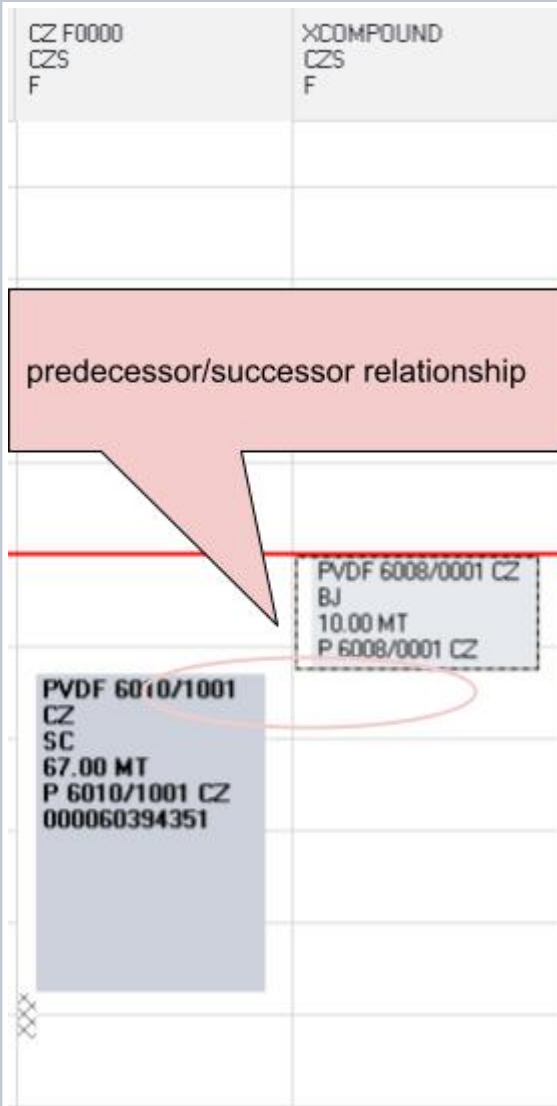
Transition Time: 0 days 0 hrs 0 mins

Transition Process: Qty: 0

Config Change Time: 0 days 0 hrs 0 mins

Setup Time: 0 days 0 hrs 0 mins

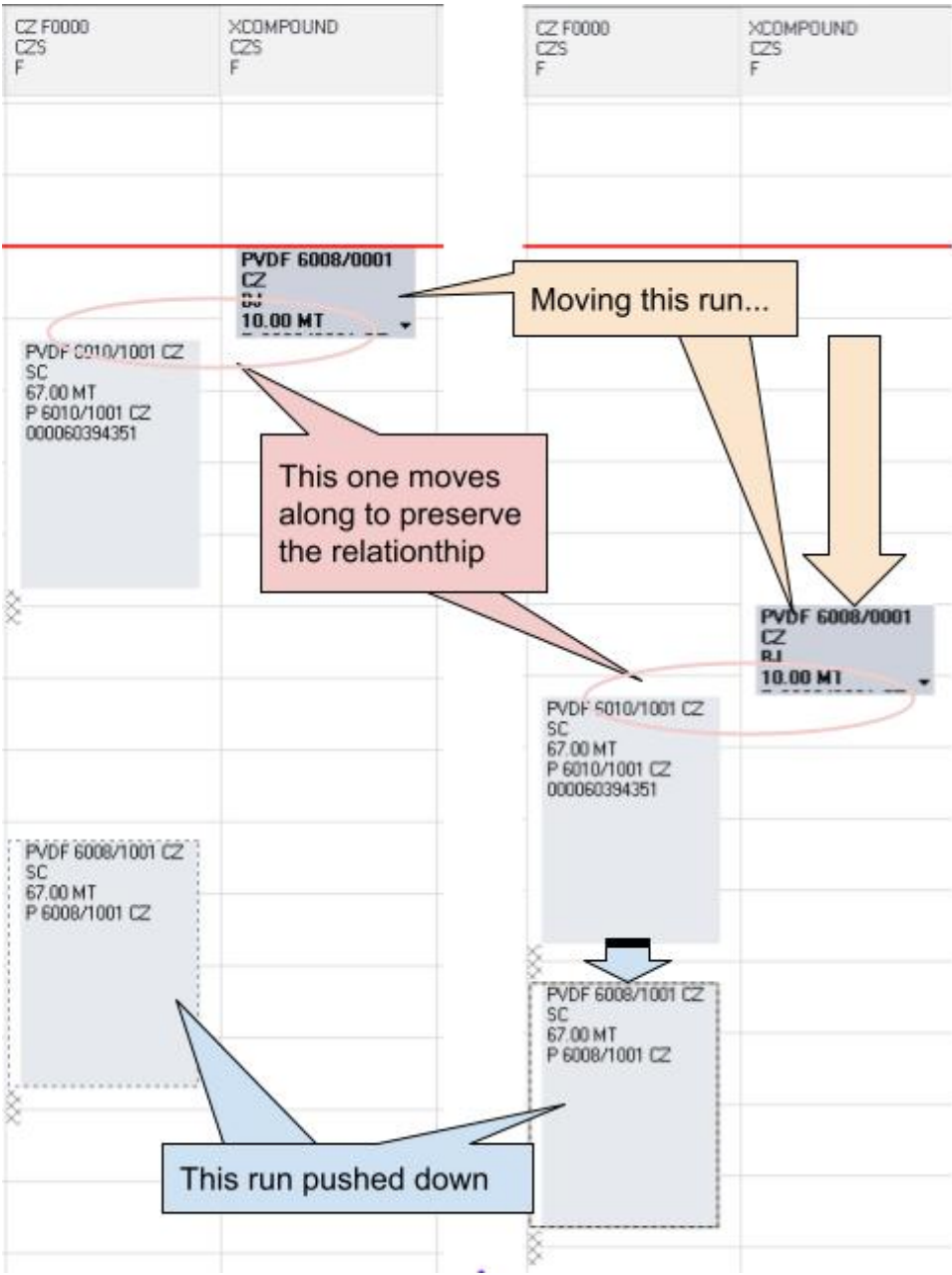
Once saved, the runs are linked. In this example, the PVDF 6006/0001 CZ run on XCOMPOUND is the predecessor and the PVDF 6010/1001 CZ is the successor.



Note that because of this relationship, the later run to the left (PVDF 6010/1001 CZ) was pushed down to meet the requirements of that relationship.

Now that these runs are linked together, moving one run results in the other run moving too to comply with the link properties.

Any other run in the way will be pushed down.



Hit the  key to cancel the relationship.

Notes

Free text. A yellow icon in the run header

PVDF 6008/0001 CZ  
BJ  
250.00 Lots  
P 6008/0001 CZ

signals that there is something there.

Notes can also be inherited from Production Standard Notes and Formulation Notes.

The screenshot shows the 'Run Properties' dialog box with the 'Notes' tab selected. The dialog has a title bar with a close button. Below the title bar are six tabs: 'General', 'Formula', 'Predecessors', 'Successors', 'Notes', and 'Orders'. The 'Notes' tab is active, showing three text areas: 'Production Standard Notes:', 'Formulation Notes:', and 'Run Notes:'. The 'Run Notes:' area contains the text 'One does not simply walk into Mordor'. At the bottom right of the dialog are three buttons: 'Calc Size', 'OK', and 'Cancel'. A purple circle highlights a yellow icon in the run header of the main window on the left.

Copy from another run

Copying multiple runs

Modifying a run

Moving a run

Deleting one/multiple runs

Inserting a floating downtime

Units of measure and lot sizing

As long as they have been defined, other units of measure can be used

Lot Size:  MT

☐ Quantity: 

MT  
MT  
Lots  
Pkgs

☐ Rate:  MT/Prod

## Package

Picking package let you enter quantity in multiple of a the material package code. Here, 25 kg bags. The 25 kg is defined in the [packages table of ADM](#)

Lot Size:  MT

☐ Quantity: 

Pkgs

 x 0.025 MT per pkg = 0.00 MT

0.00 MT Gross Production at  % Yield and 80.00 Op %

15 kg bags will therefore translate in a 380 kg run.

Lot Size:  MT

☐ Quantity: 

Pkgs

 x 0.025 MT per pkg = 0.38 MT

0.38 MT Gross Production at  % Yield and 80.00 Op %

## Lot size

Going with Lots let you enter quantity in multiple of one lot size. Here, 1 MT. The lot size comes from the [Production Standard](#) for this material on this line.

Lot Size:  MT

☐ Quantity: 

Lots

 x 1.00 MT per lot = 0.00 MT

0.00 MT Gross Production at  % Yield and 80.00 Op %

This default lot size can be modified in the run itself (and for the sake of this example, we will do just that). Lot size is now 0.35 MT per lot.



once modified in the run, it updates the corresponding production standard in ADM.

Lot Size:  MT

☐ Quantity: 

Lots

 x 0.35 MT per lot = 0.00 MT

0.00 MT Gross Production at  % Yield and 80.00 Op %

Lot Size: 0.35 MT

Quantity: 250 Lots x 0.35 MT per lot = 87.50 MT

87.50 MT Gross Production at 100 % Yield and 80.00 Op %

| Production Standards (Material = PVDF 6008/0001 CZ)                                                                                                                                                                                                                 |                   |         |          |         |         |         |         |          |         |         |       |           |          |                |          |          |          |            |
|---------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|-------------------|---------|----------|---------|---------|---------|---------|----------|---------|---------|-------|-----------|----------|----------------|----------|----------|----------|------------|
| Refresh            Edit            Add            Copy            Delete            Show/Hide Filter            Clear Filter            Excel Import            Excel Export            Reset Settings            Fields            Production Standard Effectivity |                   |         |          |         |         |         |         |          |         |         |       |           |          |                |          |          |          |            |
| Unit                                                                                                                                                                                                                                                                | Material          | Package | Lot Size | Min Run | Default | Yield % | Up time | Batch Re | Co-Prod | Co-Prod | Notes | Setup Tir | Configur | Cycle Position | Cycle Fr | Allow Sk | Qty Incr | Pct of Tot |
| XCOMPOUND                                                                                                                                                                                                                                                           | PVDF 6008/0001 CZ | BJ      | 1        | 1       |         | 100     | 80      | 0        |         | 0       |       | 0         |          | 0              | 1        |          | 0        | 100        |

Picasso calculates changeover times between runs (if configured in [ADM](#)).

The transition in the right-hand screen screenshot, indicated by XXX, is generated automatically.

The diagram illustrates three screenshots of the Picasso interface, each showing a list of runs. Callouts explain the transition times between runs:

- Top Screenshot:** Shows a transition from run IXEF 1032/9008 (C4, 15.00 MT, TxAJ, 1081412787) to run IXEF 1032/9008 (BJ, 20.00 MT, TxAJ, 1081412785). The callout indicates "No transition".
- Middle Screenshot:** Shows a transition from run IXEF 1032/9008 (BJ, 20.00 MT, TxAJ, 1081412785) to run IXEF 1521/9008 (C4, 8.00 MT, TxAJ, 1081412787). The callout indicates "Transition time = 240 min".
- Bottom Screenshot:** Shows a transition from run IXEF 1521/9008 (C4, 8.00 MT, TxAJ, 1081412787) to run IXEF 1521/9008 (BJ, 15.00 MT, TxAJ, 1081412779). The callout indicates "No transition".

The duration is derived from the transition matrix assigned to the line (here, line CO4 in Oudenaarde) in the [equipment table](#).

Equipment

RefreshEditAddCopyDeleteShow/Hide Filter

| Unit Name | Local | Area Code | Facility | Default Rate | Standard | Operation  | Up | Hit | T |
|-----------|-------|-----------|----------|--------------|----------|------------|----|-----|---|
| co4       | au    |           |          |              |          |            |    |     |   |
| CO4       | AUA   | PP-PI     | CO4      | 1            | Qty/Hour | Continuous | 98 | 98  | C |

Editing Equipment

\*Unit NameCO4

\*LocationAUA - OUDENAARDE

\*Area CodePP-PI

\*FacilityCO4

Default Rate1

Standard Rate UnitsQty/Hour

Operation ModeContinuous

Up Rate (%)98

Hit Rate (%)98

Transition MatrixOudenaarde

Cycle Length (days)30

The transition matrix itself can be found in the ADM [Transition Table](#).

If the Default checkbox is activated, the Default values are used.

Here, there is a default Down time of 240 min.

Transitions

RefreshEditAddCopyDeleteShow/Hide Filter

| Matrix Code | Description | Default Transition (mins) | Product |
|-------------|-------------|---------------------------|---------|
|             |             |                           |         |

Editing Transitions

\*Matrix Code13

DescriptionOudenaarde

Default Transition (mins)0

Product ClassFinished Products

Use Default

Default Transition MaterialTRANS

Default Transition Qty0

Default Down Time (mins)240

Default Cost0

Save

In this example, no product-to-product specific record match the actual run sequence.

Hence, default duration being used (240 min).



**Transitions**

Refresh Edit Add Copy Delete ShowHide Filter Clear Filter Excel Import Excel Export Reset Settings Fields Transition Element

| Matrix Code | Description | Default Transition (mins) | Product Class | Use Default | Default Transition Material | Default Transition |
|-------------|-------------|---------------------------|---------------|-------------|-----------------------------|--------------------|
|             | ouden       |                           |               |             |                             |                    |
| 12          | Oudehaarde  |                           |               |             |                             |                    |

Transition Element' key takes you to the product-to-product specific transitions

**Transition Elements (Matrix Code = 13)**

Refresh Edit Add Copy Delete ShowHide Filter Clear Filter Excel Import Excel Export Reset Settings Fields

| Matrix Code | Initial Material | Final Material | Trans Mat | Allow Seq | Down Time | Transition Time (mins) | Transition Qty | Trans Cost |
|-------------|------------------|----------------|-----------|-----------|-----------|------------------------|----------------|------------|
| 13          | TFSF             | TWRB           |           |           | 2400      | 0                      | 0              |            |
| 13          | TFSK             | TWRB           |           | ✓         | 2400      | 0                      | 0              |            |
| 13          | TFSF             | TWRB           |           | ✓         | 2400      | 0                      | 0              |            |
| 13          | TFTF             | TWRB           |           | ✓         | 2400      | 0                      | 0              |            |
| 13          | TFTF             | TRGA           |           | ✓         | 2400      | 0                      | 0              |            |
| 13          | TFWD             | TWRB           |           | ✓         | 2400      | 0                      | 0              |            |
| 13          | TFWC             | TKDR           |           | ✓         | 2400      | 0                      | 0              |            |
| 13          | TRGA             | TFSP           |           | ✓         | 2400      | 0                      | 0              |            |
| 13          | TRGA             | TFSK           |           | ✓         | 2400      | 0                      | 0              |            |
| 13          | TRGA             | TFSP           |           | ✓         | 2400      | 0                      | 0              |            |
| 13          | TRGA             | TFWC           |           | ✓         | 2400      | 0                      | 0              |            |
| 13          | TRGA             | TFWD           |           | ✓         | 2400      | 0                      | 0              |            |
| 13          | TMKN             | TPLU03         |           |           | 2100      | 0                      | 0              |            |
| 13          | TMKN             | TPDU04         |           |           | 2100      | 0                      | 0              |            |
| 13          | TMKN             | TPBL           |           |           | 2100      | 0                      | 0              |            |
| 13          | TMKN             | TPDQ           |           |           | 2100      | 0                      | 0              |            |
| 13          | TXAJ             | TXAJ           |           |           | 2400      | 0                      | 0              |            |
| 13          | TXAJ             | TXAJ           |           |           | 2400      | 0                      | 0              |            |
| 13          | TXAJ             | TXAJ           |           |           | 2400      | 0                      | 0              |            |

Only one record for TXAJ (transition to self)  
Therefore default is used

**Editing Transition Elements (Matrix Code = 13)**

\*Matrix Code 13

\*Initial Material TXAJ

\*Final Material TXAJ

Trans Material

Allow Seq ☒

Down Time

Transition Time (mins)

Transition Qty

\*Transition Cost

Instead of a list of product-to-product transition being maintained in the transition matrix, groups of products are defined. The transition rules are defined at group level.

Transitions by Groups

Refresh

Edit

Add

Copy

Delete

Show/Hide Filter

Clear Filter

Excel Import

| Matrix Code | Init Type   | Init Object                             | Final Type  | Final Object |
|-------------|-------------|-----------------------------------------|-------------|--------------|
| 0           |             |                                         |             |              |
| Oudenaarde  | Trans Group | CO5 Amodel Black Gr 1 - CO5AB1          | Trans Group | CO5 Amodel B |
| Oudenaarde  | Trans Group | CO5 Amodel Black Gr 3 - CO5 AMODEL BK 3 | Trans Group | CO5 Amodel B |
| Oudenaarde  | Trans Group | CO5 Amodel Black Gr 1 - CO5AB1          | Trans Group | CO5 Amodel B |

Editing Transitions by Groups

\*Matrix Code

Oudenaarde

\*Init Type

Trans Group

\*Init Object

CO5 Amodel Black Gr 3 - CO5 AMODEL BK 3

\*Final Type

Trans Group

\*Final Object

CO5 Amodel Black Gr 2 - CO5 AMODEL BK 2

Trans Product

Down Time

720

Allow Seq

☒

Transition Time (mins)

0

Transition Qty

0

\*Transition Cost

0

\*Record ID

4117

Save

Groups are defined in the [Classification table](#), and products are assigned to them.

| Members (Class = CO5AB3)                                                                  |                                                                                        |                                                                                       |                                                                                         |                                                                                         |
|-------------------------------------------------------------------------------------------|----------------------------------------------------------------------------------------|---------------------------------------------------------------------------------------|-----------------------------------------------------------------------------------------|-----------------------------------------------------------------------------------------|
|  Refresh |  Edit |  Add |  Copy |  Del |
| Class                                                                                     | Group                                                                                  | Member                                                                                |                                                                                         |                                                                                         |
| CO5AB3                                                                                    | CO5AB3                                                                                 | TFAR                                                                                  |                                                                                         |                                                                                         |
| CO5AB3                                                                                    | CO5AB3                                                                                 | TFSN                                                                                  |                                                                                         |                                                                                         |

## Equipment Calendars

Lines recurring downtimes (i.e. weekends, shifts, etc.) are maintained there.

In this example, lines CO2, CO3 & CO4 are down every WE.

Line CO5 is a 24/7 type line.

|        | CO2<br>AUA<br>F | CO3<br>AUA<br>F | CO4<br>AUA<br>F | CO5<br>AUA<br>F |
|--------|-----------------|-----------------|-----------------|-----------------|
| jun 23 |                 |                 |                 |                 |
| jun 24 |                 |                 |                 |                 |
| jun 25 |                 |                 |                 |                 |
| jun 26 |                 |                 |                 |                 |
| jun 27 |                 |                 |                 |                 |
| jun 28 |                 |                 |                 |                 |
| jun 29 |                 |                 |                 |                 |
| jun 30 |                 |                 |                 |                 |
| jul 01 |                 |                 |                 |                 |
| jul 02 |                 |                 |                 |                 |

Lines CO2 CO3 and CO4 are assigned to "24 Hours/5 Days" calendar

Line CO5 is assigned to "24 H/6 D OUD" calendar.

| Equipment |                   |            |                   |            |          |      |           |       |                 |                      |                 |                |                  |                          |                  |
|-----------|-------------------|------------|-------------------|------------|----------|------|-----------|-------|-----------------|----------------------|-----------------|----------------|------------------|--------------------------|------------------|
|           |                   |            |                   |            |          |      |           |       |                 |                      |                 |                |                  |                          |                  |
| Unit Name | Standard Operator | Up Hrs     | Transition Matrix | Cycle Ld   | Wip Keep | Type | Bel Class | Owner | Min Run         | (Lag Hrs)            | Config Chd User | Production Pkg | Consumption Pkg  | Wave/Job Sched           | Col (C) of P (R) |
| ISO       |                   |            |                   |            |          |      |           |       |                 |                      |                 |                |                  |                          |                  |
| CO2       | Qty/Hour          | Continuous | 98                | Oudenaarde | 30       | 7    | ACI       | 0     | Finishing Lines | Oudenaarde Schedul 1 | 0               | 0              | BJ - BAGS, 25 KG | CS - BOX, 500 UNITS Jump | Qty              |
| CO3       | Qty/Hour          | Continuous | 98                | Oud Line2  | 30       | 7    | ACI       | 0     | Finishing Lines | Oudenaarde Schedul 1 | 0               | 3              | BJ - BAGS, 25 KG | CS - BOX, 500 UNITS Jump | Qty              |
| CO4       | Qty/Hour          | Continuous | 98                | Oud CO4    | 30       | 7    | ACI       | 0     | Finishing Lines | Oudenaarde Schedul 1 | 0               | 0              | BJ - BAGS, 25 KG | CS - BOX, 500 UNITS Jump | Qty              |
| CO5       | Qty/Hour          | Continuous | 98                | Oud CO5    | 30       | 7    | ACI       | 0     | Finishing Lines | Oudenaarde Schedul 1 | 0               | 0              | BJ - BAGS, 25 KG | CS - BOX, 500 UNITS Jump | Qty              |

"24 Hours/5 Days" calendar shows that Sundays and Saturdays are off.

Equipment Calendars

Refresh

Edit

Add

Copy

Delete

Show/Hide Filter

Clear Filter

| Calendar Name       | Sunday                              | Monday | Tuesday | Wednesday | Thursday | Friday | Saturday | Sunday |
|---------------------|-------------------------------------|--------|---------|-----------|----------|--------|----------|--------|
| 24                  | <input type="checkbox"/>            |        |         |           |          |        |          |        |
| 24 H-7 D            | <input checked="" type="checkbox"/> |        |         |           |          |        |          |        |
| 24 Hours/5 Days     | <input type="checkbox"/>            |        |         |           |          |        |          |        |
| 24 Hours/4 Days     |                                     |        |         |           |          |        |          |        |
| 24 Hours 6 days     | <input checked="" type="checkbox"/> |        |         |           |          |        |          |        |
| 24Hours 6 days SMF  |                                     |        |         |           |          |        |          |        |
| 24//6 CZS           |                                     |        |         |           |          |        |          |        |
| 24 H-3 Days/12 H- 1 |                                     |        |         |           |          |        |          |        |
| 24h/7d SM           | <input checked="" type="checkbox"/> |        |         |           |          |        |          |        |
| 24 H/ 6 D OUD       | <input checked="" type="checkbox"/> |        |         |           |          |        |          |        |

Editing Equipment Calendars

\*Calendar Name24 Hours/5 Days

Sunday Workday?

Monday Workday?

Tuesday Workday?

Wednesday Workday?

Thursday Workday?

Friday Workday?

Saturday Workday?

Sunday Start

Monday Start

Tuesday Start

Wednesday Start

Thursday Start

Friday Start

Saturday Start

Sunday End

Monday End

Tuesday End

Wednesday End

Thursday End

Friday End

Saturday End

Description

Max Push Days

☐

☒

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3/23/2013 12:00:00 AM

3/23/2013 12:00:00 AM

3/23/2013 12:00:00 AM

3/23/2013 12:00:00 AM

3/23/2013 12:00:00 AM

3/23/2013 11:59:00 PM

3/23/2013 11:59:00 PM

3/23/2013 11:59:00 PM

3/23/2013 11:59:00 PM

3/23/2013 11:59:00 PM

24 Hours/5 Days

365

Save

"24 H/6 D OUD" calendar configuration shows that all days are working days.

Equipment Calendars

Refresh

Edit

Add

Copy

Delete

Show/Hide Filter

Clear Filter

| Calendar Name         | Sunday | Monday | Tuesday | Wednesday | Thursday | Friday | Saturday |
|-----------------------|--------|--------|---------|-----------|----------|--------|----------|
| 24                    |        |        |         |           |          |        |          |
| 24 H-7 D              |        |        |         |           |          |        |          |
| 24 Hours/5 Days       |        |        |         |           |          |        |          |
| 24 Hours/4 Days       |        |        |         |           |          |        |          |
| 24 Hours 6 days       |        |        |         |           |          |        |          |
| 24Hours 6 days SMF    |        |        |         |           |          |        |          |
| 24//6 CZS             |        |        |         |           |          |        |          |
| 24 H-3 Days/12 H- 1 d |        |        |         |           |          |        |          |
| 24h/7d SM             |        |        |         |           |          |        |          |
| 24 H/6 D OUD          |        |        |         |           |          |        |          |

Editing Equipment Calendars

\*Calendar Name24 H/ 6 D OUD

Sunday Workday?

Monday Workday?

Tuesday Workday?

Wednesday Workday?

Thursday Workday?

Friday Workday?

Saturday Workday?

Sunday Start7/1/2020 6:00:00 PM

Monday Start7/1/2020 12:00:00 AM

Tuesday Start7/1/2020 12:00:00 AM

Wednesday Start7/1/2020 12:00:00 AM

Thursday Start7/1/2020 12:00:00 AM

Friday Start7/1/2020 12:00:00 AM

Saturday Start7/1/2021 12:00:00 AM

Sunday End7/1/2020 11:59:00 PM

Monday End7/1/2020 11:59:00 PM

Tuesday End7/1/2020 11:59:00 PM

Wednesday End7/1/2020 11:59:00 PM

Thursday End7/1/2020 11:59:00 PM

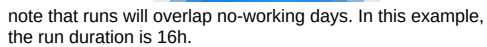
Friday End7/1/2020 11:59:00 PM

Saturday End7/1/2021 5:59:00 PM

Description24 H/ 6 D OUD

Max Push Days365

Save



|                                                        |                 |  |  |
|--------------------------------------------------------|-----------------|--|--|
| C04<br>AUA<br>F                                        | C05<br>AUA<br>F |  |  |
| IXEF 1032/9008<br>BJ<br>20.00 MT                       |                 |  |  |
| IXEF 1521/9008<br>BJ<br>20.00 MT<br>TXAP<br>1082454900 |                 |  |  |

### Run Properties

| General                                                                                                 | Formula | Predecessors   | Successors | Notes |
|---------------------------------------------------------------------------------------------------------|---------|----------------|------------|-------|
| Line: C04                                                                                               |         |                |            |       |
| Sku Code: 0127262                                                                                       |         | N-MXD6 (IXEF)  |            |       |
| Product: TXAP                                                                                           |         | IXEF 1521/9008 |            |       |
| Package: BJ                                                                                             |         | BAGS, 25 KG    |            |       |
| Formula: 22218-AUA-BJ-18-L4-Z-RADIPOL-3540-HY                                                           |         |                |            |       |
| Start : 05 / 05 / 2023 at 11 : 58 : 00                                                                  |         |                |            |       |
| <input type="checkbox"/> Run Should Start On or After this date and time: <div> / / at : : : </div>     |         |                |            |       |
| Lot Size: 1.0000 MT                                                                                     |         |                |            |       |
| <input type="radio"/> Quantity: 20.00 MT <div> 20.41 MT Gross Production at 98 % Yield and 98.00 </div> |         |                |            |       |
| <input type="radio"/> Rate: 1.3000 MT/Hour << 1.3000 (std rate)                                         |         |                |            |       |
| <input checked="" type="radio"/> Duration: 0 days 16 hr 1 min Ends: 06 / 05 / 2023 at 03                |         |                |            |       |
| Run Reference #: 10619691 <input type="checkbox"/> Output Rep                                           |         |                |            |       |
| Status: <input type="checkbox"/> Completed                                                              |         |                |            |       |
| Customer Order: 1082454900 <input checked="" type="checkbox"/> Exportable                               |         |                |            |       |
| Lot Number: <input type="text"/> Type: Free                                                             |         |                |            |       |
| Link Info:                                                                                              |         |                |            |       |

Calc Size OK

This is where you want to manage your shutdowns and fixed downtimes.

Insert a fixed downtime in the [Equipment Calendar Events](#) table.

| Calendar Name | Event Name     | Event Type | All Day Event?                      | Event Start        |
|---------------|----------------|------------|-------------------------------------|--------------------|
| 24 H/ 6 D OUD | Planned stop   | 0          | <input checked="" type="checkbox"/> | 7/15/2023 12:00:00 |
| Default       | New Year's Day | 0          | <input type="checkbox"/>            | 1/1/2006 12:00:00  |
| PFR 2         |                |            |                                     |                    |
| PFR 2         |                |            |                                     |                    |

Editing Equipment Calendar Events

\*Calendar Name

24 H/ 6 D OUD

\*Event Name

Planned stop

Event Type

0

All Day Event?

☒

Event Start

7/15/2023 12:00:00 AM

Event End

8/4/2023 12:00:00 AM

Save

Cancel

It will create show on the Schedule



that event will only update after the overnight jobs. Hence, 24h after the event is inserted in the calendar

|        | C02<br>AUA<br>F                                        | C03<br>AUA<br>F | C04<br>AUA<br>F | C05<br>AUA<br>F |                                            |
|--------|--------------------------------------------------------|-----------------|-----------------|-----------------|--------------------------------------------|
| jul 20 |                                                        |                 |                 |                 |                                            |
| jul 21 |                                                        |                 |                 |                 |                                            |
| jul 22 |                                                        |                 |                 |                 |                                            |
| jul 23 |                                                        |                 |                 |                 |                                            |
| jul 24 |                                                        |                 |                 |                 |                                            |
| jul 25 |                                                        |                 |                 |                 |                                            |
| jul 26 |                                                        |                 |                 |                 |                                            |
| jul 27 |                                                        |                 |                 |                 |                                            |
| jul 28 |                                                        |                 |                 |                 |                                            |
| jul 29 |                                                        |                 |                 |                 |                                            |
| jul 30 |                                                        |                 |                 |                 |                                            |
| jul 31 |                                                        |                 |                 |                 |                                            |
| aug 01 | MTO/PARA USAGE<br>BJ<br>70.00 MT<br>TXCD<br>1082462541 |                 |                 |                 |                                            |
| aug 02 |                                                        |                 |                 |                 |                                            |
| aug 03 |                                                        |                 |                 |                 |                                            |
| aug 04 |                                                        |                 |                 |                 |                                            |
|        |                                                        |                 |                 |                 | PPS XE5000NA.010<br>C4<br>35.00 MT<br>TRBR |



Note that a fixed downtime applies to a calendar. Hence to all lines assigned to that calendar.

## Saving a schedule



Only one person may edit a schedule at a time.

One person editing, other people displaying is fine.

[blocked URL](#)

Some plants created a Google Chat Room to check with other site planners when going in a schedule in edit mode

## to Master Schedule as a Scenario

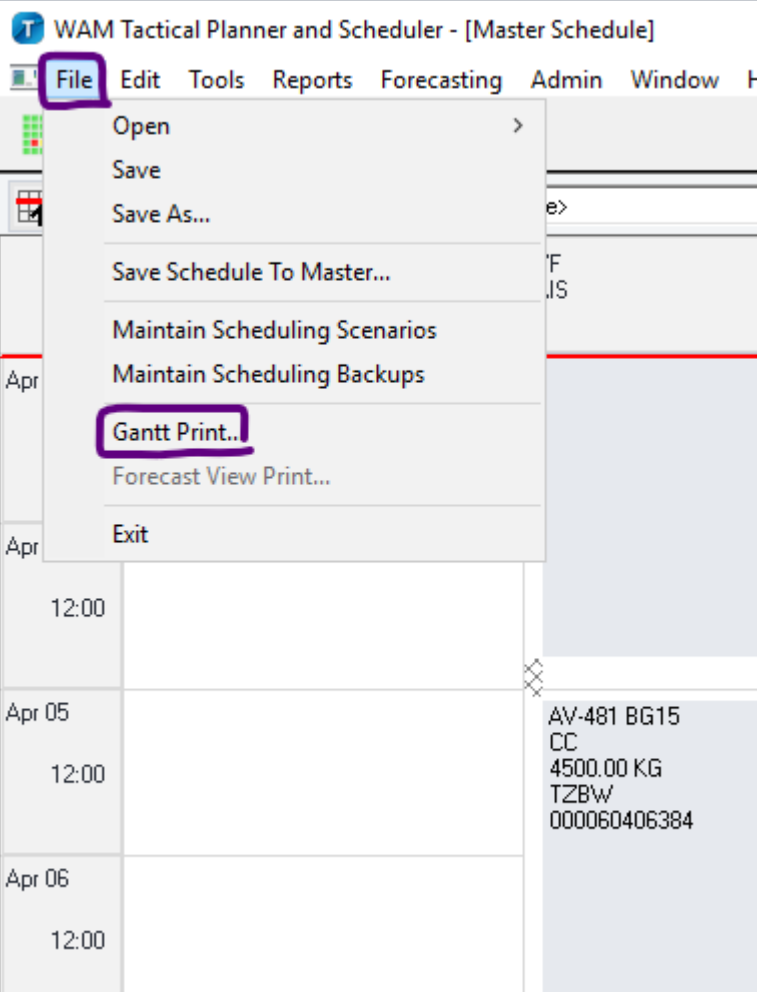
## Production Schedule upload to SAP

The production schedule is uploaded once a day into SAP. For more on this, read the corresponding [note](#).

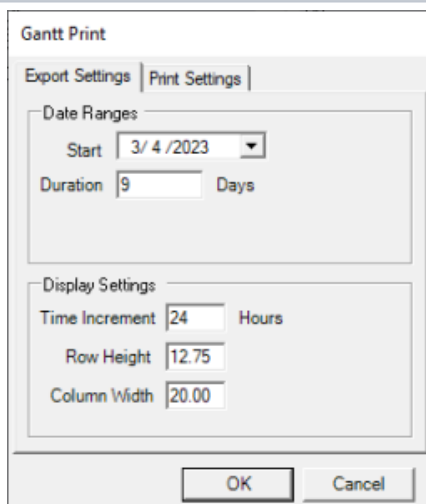
On-demand upload is also supported. Security must be given to a user to be allowed to upload the schedule. When running on-demand, runs on lines /locations that the user is allowed for are uploaded into SAP. More about this [here](#).)

## Print a schedule

From the menu, pick "Gantt Print..."

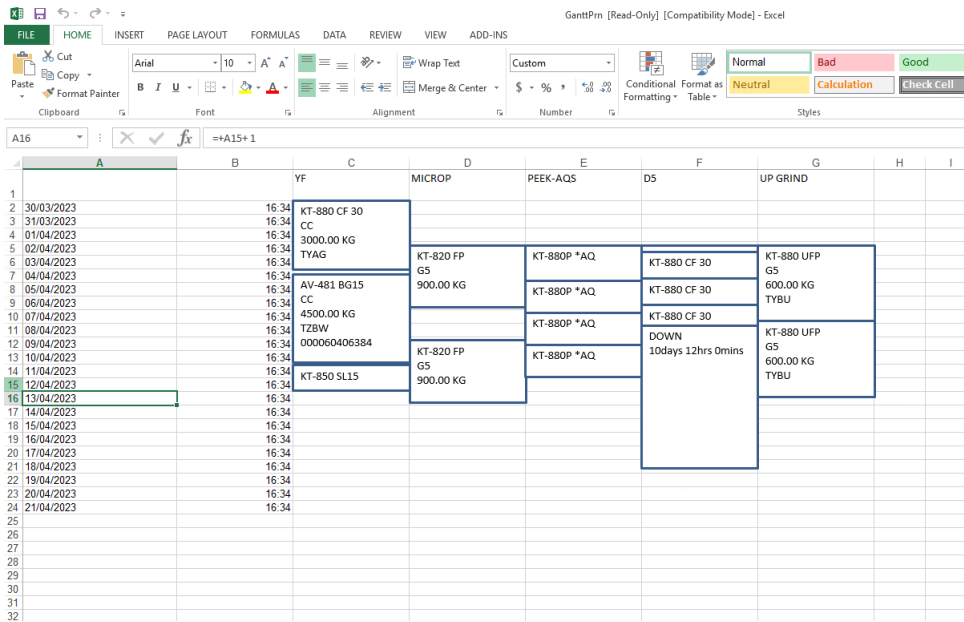


Hit 'OK'



It opens an Excel spreadsheet.

The layout of the Gantt may be configured: click "Add-ins", then "Time Scale", then "encho



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Edit Time Scale

Start Date

3/30/2023

Start Time

4:34:00 PM

Duration

21

(days)

Time Increment

24

(hours)

Row height

13

OK

Cancel

## Dynamic Scheduling

Dynamic Scheduling is an add-on to standard Picaso. It enables the generation of a production schedule with more sophisticated which, contrary to the standard, can account for the production wheel, production cycle, and other constraints that can be programmed.